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4084975

D2005-011
Job Sheet 179778



Part No: D2005-011

Job Qty: 2 ea

Part Name: Union



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 6/29/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: D2005-011 rev.c IPP B 99.08.24 Re-format DM/EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	2 Ea		6/29/18	0.00	0.00	Start Up Machining-4		
110	Mill Conv	2 pcs		6/29/18	0.00	0.33	Mill Conv 1		
120	QC	2 pcs		6/29/18	0.00	0.00	QC5		
130	Small Fab	2 pcs		6/29/18	0.00	0.33	Small Fab-9		
140	QC	2 pcs		6/29/18	0.00	0.00	QC5		
150	Packaging	2 pcs		6/29/18	0.00	0.00	Packaging3-2		
160	QC21-SA	2 Ea		6/29/18	0.00	0.00	QC21		

Part Op 110 - Machine elbow P/N: AN833-8J per Dwg. D2005-011

Descriptions: 130 - Press fit D2005-003 restrictor in place as per Dwg. D2005-011 Note: (15° chamfer towards inside of fitting) Stake restrictor in place using clean ballpeenhammer to tap down edge. Polish smooth finish

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN833-8J	Elbow, Bulkhead-M-Flare	2 Ea (1 ea)	100-Start up Operation	
D2005-003	Restrictor	2 pcs (1 ea)	100-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	AN833-8J	2	0	0
	D2005-003	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : 18/6/27	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval INSP 12 <i>[Signature]</i> 18/6/27																	
Description Work Order Deviation			Disposition																		
D2055-063 WAS PRESS FIT WITH MIN 0.002 INTERFERENCE. PART WAS NOT STAKED PER DUG.			Acceptable. By ensuring 0.002 of interference, staking is redundant.																		
			Completed By <i>[Signature]</i> 18/6/27																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		

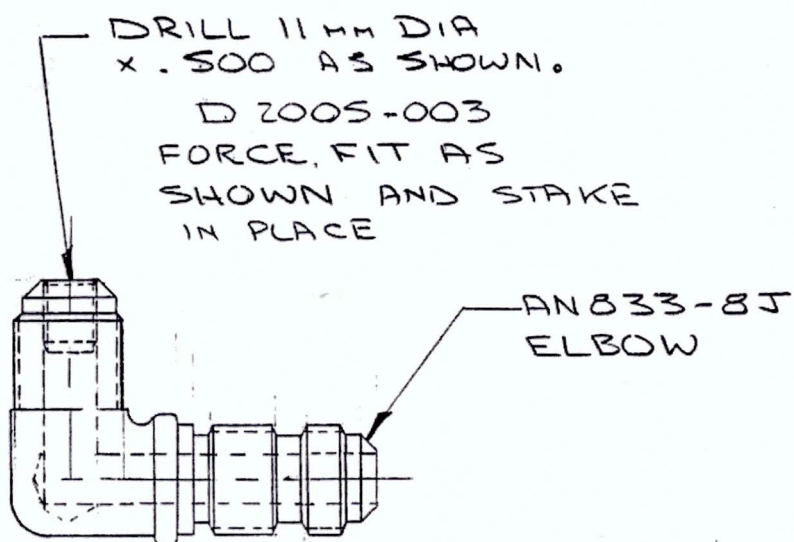
Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

DART



DESIGN BRADLEY	DRAWN BY BRADLEY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2005-011	REV C SHEET 1 OF 1
DATE 26.04.17		TITLE RESTRICTOR ELBOW	
C		REDRAWN 26.04.17 <i>[Signature]</i>	

RELEASED
97/09/03 DS



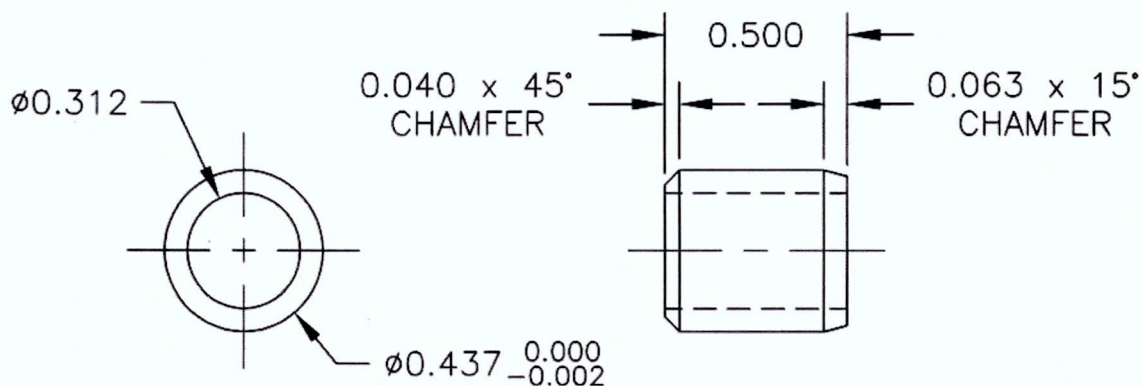
DETAIL OF D2005-011

SCALE 1:1



DESIGN JB	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2005-003	REV. E SHEET 1 OF 1
DATE 03.05.01		TITLE RESTRICTOR	SCALE 2:1
C	96.04.17	REDRAWN	
D	97.09.03	304 S.S. SPEC ADDED	
E	03.05.01	ADDED TOLERANCE TO $\phi 0.437$	

RELEASED
03.05.07 *H*



NOTE:

- 1) MATERIAL: $\phi 0.50$ AISI 303 ROUND BAR (REF DART SPEC. M303R0.500) OR $\phi 0.435$ AISI 302/304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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